



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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647.1702
Job Sheet 181429



Part No: 647.1702

Job Qty: 4 ea

Part Name: Skid Deflector Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 13.07.17 JLM VERIFIED BY:DD IPP REV:B 14.09.26 AS PER DWG C1 DD VERF:JLM

Ship Via:

7013

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Stores/Pkg-1		DEC 12 2018
120	Small Fab	4 pcs	9/10/18	9/10/18	0.00	1.64	Small Fab-1		DEC 12 2018
130	QC	4 pcs	9/10/18	9/10/18	0.00	0.00	QC5		DEC 12 2018
190	Small Fab	4 pcs	9/10/18	9/10/18	0.00	1.64	Small Fab-1		DEC 12 2018
200	QC	4 pcs	9/10/18	9/10/18	0.00	0.00	QC5		DEC 12 2018
210	Packaging	4 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		DEC 12 2018
220	QC21-SA	4 Ea	9/10/18	9/10/18	0.00	0.00	QC21		DEC 12 2018

Part Op 120 - 1- Assemble item 4,6,7 and 8 as per dwg. 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note
Descriptions: 6. Use clecos. 3- Disassemble parts 4- Deburr 5- Touch up expose aluminum with alodine 6- Re-assemble as per dwg ***

***TOUCH UP RIVET WITH PRIMER *** PRIMER BATCH: ***

190 - ASSEMBLE AS PER DWG

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1712	Gusset	4 Ea (1 ea)	90-Start up Operation	5051140
647.1713	Spacer	4 Ea (1 ea)	90-Start up Operation	5051140
647.1714	Plate	4 Ea (1 ea)	90-Start up Operation	5041780
647.1715	Plate	4 Ea (1 ea)	90-Start up Operation	5023595
CR3213-4-4	Rivet, Cherry	88 Ea (22 ea)	90-Start up Operation	5041780
MS21042L3	Nut	4 Ea (1 ea)	90-Start up Operation	5041780
MS27039-1-14	Screw	4 Ea (1 ea)	90-Start up Operation	5041780
NAS1149F0332P	Washer	8 Ea (2 ea)	90-Start up Operation	5131206

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	647.1712	4	21	0
	647.1713	4	12	0
	647.1714	4	16	0
	647.1715	4	11	0
	CR3213-4-4	88	433	0
	MS21042L3	4	4,552	0
	MS27039-1-14	4	406	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube</td><td style="width:12.5%;">☐</td> <td style="width:12.5%;">Cross tube</td><td style="width:12.5%;">☐</td> <td style="width:12.5%;">Water Jet</td><td style="width:12.5%;">☐</td> <td style="width:12.5%;">Engineering</td><td style="width:12.5%;">☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td>☐</td> </tr> </table>						Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																		
Description / Deviation				Disposition				Completed By																																	
Dart Aerospace Ltd. 1270 Aberdeen Street Hewesbury, ON K6A 1K7 CANADA S13 5S2-5200 TEL.: sales @ dartaero.com Email: sales @ dartaero.com www.dartaerospace.com Date: 12/12/18 Container No: S136992 Part: 647.1702 Job No: 181429 Serial No/ Batch: S136992 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____																																									

Part Specifications

Specifications could not be found.

Plex 7/26/18 8:39 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐	☐	Positioned Wrong ☐															
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐	Folio/Program ☐	☐	Outside Dimensions ☐															
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐	Grain ☐	☐	Over/Under tolerance ☐															
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐	Weld ☐	☐	Part Incorrect ☐															
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐	☐	Part Lost/Missing ☐															
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐	Out of Sequence ☐	☐	Part Moved ☐															
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐	Off-set ☐	☐	Drawing ☐															
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐	☐	Finish ☐															
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐	☐	Misread ☐															
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐	☐	Turning Sequence ☐															
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐																						
Misidentified ☐	☐	Past Due ☐	☐	OTHER :																					